












Date: Monday, 23/10/2006 7:23:27 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 29092		
Estimate Number	: 10368	Part Number	: D30481
P.O. Number	: N/A	Drawing Number	: D3048 REV. A2
This Issue	: 23/10/2006 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: A2
First Issue	: N/A Type : SMALL /MED FAB	Material	: N/A
Previous Run	: 28975	Due Date	: 24/10/2006
Written By	: <u> </u>	Qty:	1 Um: Each
Checked & Approved By	: <u> </u>		
Comment	: Est: A 02.11.19 New issue KJ/RF Est Rev:B Now on Waterjet 06-10-15 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
			
Comment: Qty.: 3.6312 sf(s)/Unit Total : 7.2624 sf(s) 2024-T3 .063 sheet Material: 2024-T3 (QQ-A-250/4) 0.063 thick (M2024T3S.063) Batch: <u>H16062</u> <u>FF 06-10-23</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3048 <u>make by hand</u> Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary <u>FF 06-10-23</u>			
3.0	QC3	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>FF 06-10-23</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>N/A</u>			
5.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Form on CNC Brake per Dwg D3048 <u>SP 06/10/23</u>			

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06/10/24

(D)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1806.10.23 (D)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

sent ml 06/11/03

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(D) 06/11/03

Job Completion



U 06/11/03

L Lacelle

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 20, 2006 6:26 PM
To: 'L Lacelle'
Cc: 'Dan Stow'
Subject: RE: DEO 9217
Attachments: D3048-RevA2.pdf, DEO9217-RevA.pdf

Linda/Dan,

Sorry for not getting back to you sooner.
Just wanted to review the drawings before getting back to you.
See attached D3048 drawing.
The large cutouts in the D3048-1 doubler are for REFERENCE ONLY for the Mosaic camera installation
Dan is correct. Just drill the rivet holes.

David

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Friday, October 20, 2006 7:49 AM
To: *David Shepherd (*David Shepherd)
Cc: Dan Stow (Dan Stow)
Subject: RE: DEO 9217

Any news on this?
LL

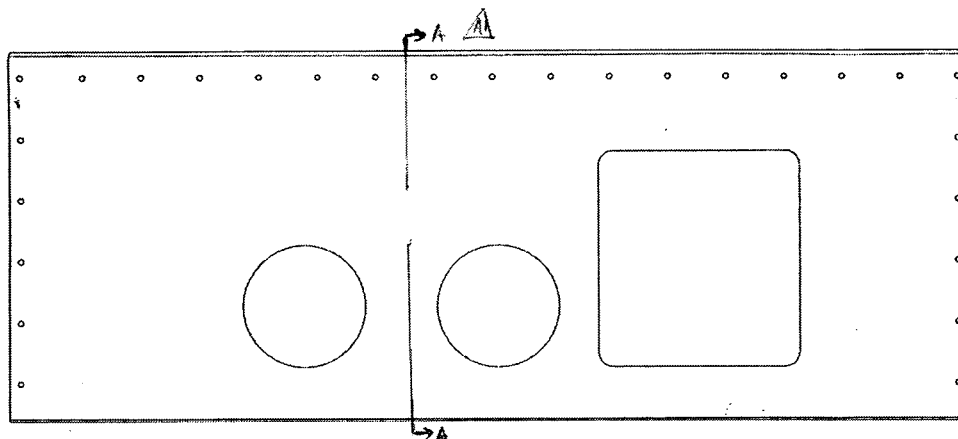
From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: October 18, 2006 8:02 AM
To: *David Shepherd (*David Shepherd)
Cc: Dan Stow (Dan Stow)
Subject: DEO 9217

Hi David,
We are making a pod 350-602*013, and Dan seems to remember that the D3048-1 doubler didn't have holes, but the drwg does...could you check this asap, I need to ship this by Nov.1
Thx
LL

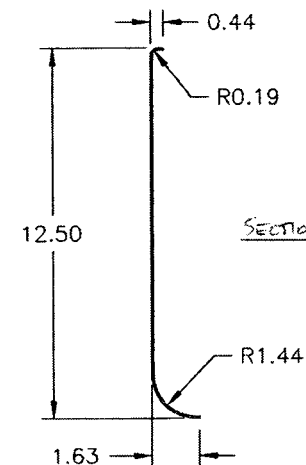
--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

--
No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.8/489 - Release Date: 10/20/2006

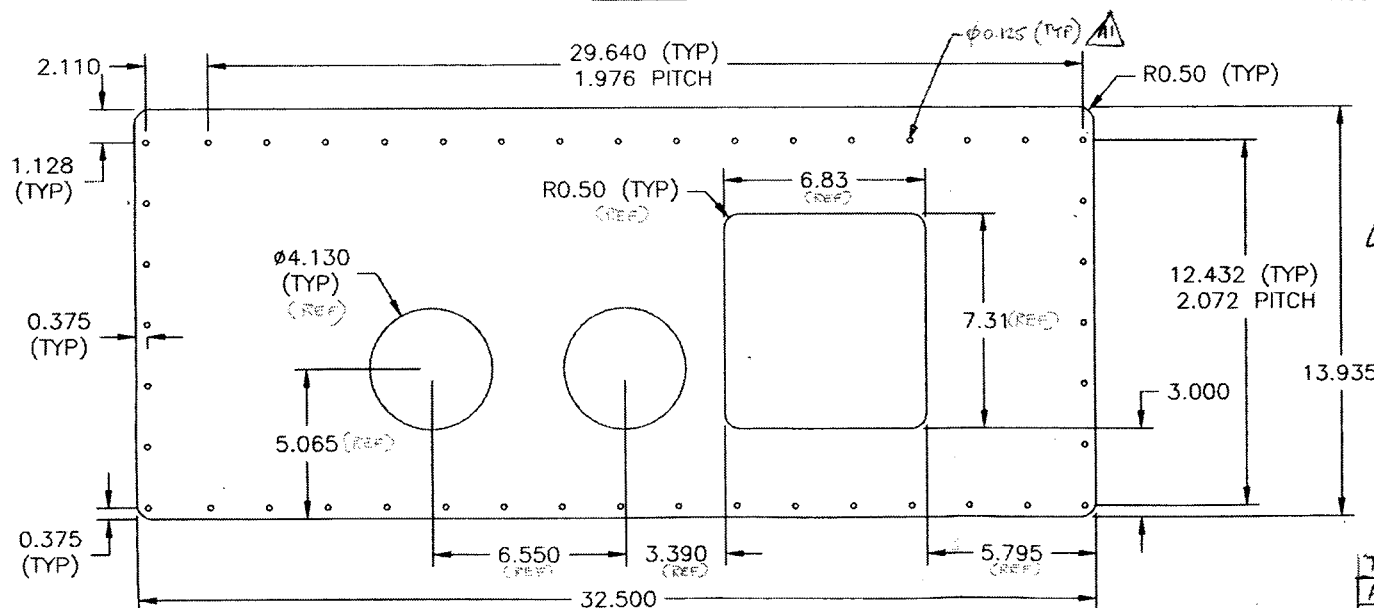
23/10/2006



D3048-1



SECTION A-A



MATERIAL: 2024-T3 (QQ-A-250/4)
0.063 THICK
FINISH: ACID ETCH, ALODINE PER DART
QSI 005 4.1
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

△ CUT-OUTS (3 PLACES) ARE SHOWN FOR REFERENCE ONLY,
DO NOT CUT.

REFERENCE UNL

REV. 1	01.09.25	REWORK CUT-OUTS
AI	02.11.20	CORRECT DWG ERRORS
A	01.09.25	NEW ISSUE
DESIGN	DRAWN BY RF	DART DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, GBR
CHECKED	APPROVED	DRAWING NO. D3048
DATE	01.09.25	TITLE DOUBLER
		REV. A SHEET 1 OF 1 SCALE 1:4

D3048-1 FLAT PATTERN

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RELEASED
01.09.27